

Work Order ID 132744

Thursday, May 07, 2015 3:09:56 PM

132744

Page 1

Item ID: D2199-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Struts, 19"
Start Date: 5/7/2015 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 5/7/2015 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: CL Date: MAR 08 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2199	F

100	NC BRAKE	0.00							
100									
Brake NC	Memo	0.01							
Brake NC	Punch per Dwg. D2199 and Spec Control Dwg D2638								
	Deburr								

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>10:15</u>								
	OVEN TEMPERATURE: <u>400°</u>								
	FINISH TIME: <u>10:15</u>								

all

DQA: _____ Date: _____

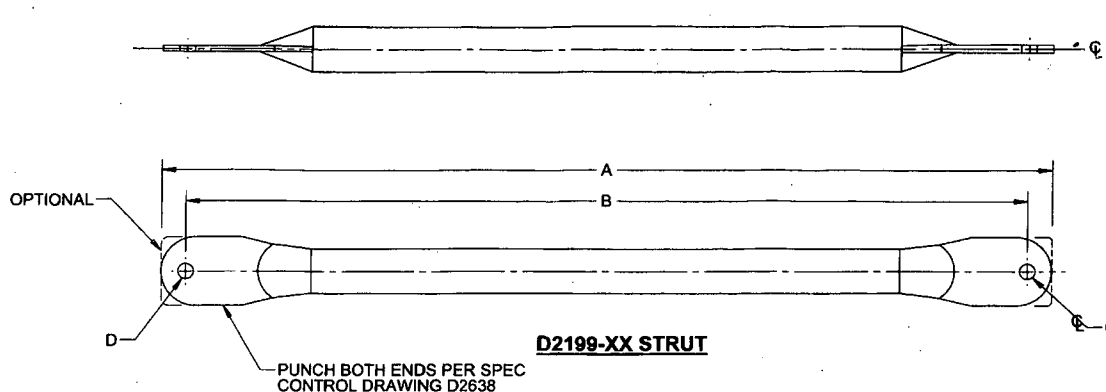
WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																	
Description Work Order Deviation		Disposition		Completed By																																																																	
				Lead hand / Supervisor Approval Verification																																																																	
				QC / QA Coordinator Approval																																																																	
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OTHER : _____																																																																					



PART NUMBER	A	B	C	D	WEIGHT (LBS)	FINISH
D2199-1	18.30	17.50	Ø0.257	Ø0.257	0.56	NOTE 2
D2199-3	5.80	5.00	Ø0.257	Ø0.257	0.17	NOTE 2
D2199-5	22.64	21.84	Ø0.257	Ø0.316	0.69	NOTE 2
D2199-7	14.74	13.94	Ø0.257	Ø0.257	0.45	NOTE 2
D2199-9	16.52	15.72	Ø0.257	Ø0.257	0.50	NOTE 2
D2199-11	23.60	22.80	Ø0.257	Ø0.316	0.72	NOTE 2
D2199-13	15.96	15.16	Ø0.257	Ø0.257	0.49	NOTE 2
D2199-15	17.57	16.77	Ø0.257	Ø0.257	0.54	NOTE 2
D2199-17	28.05	27.25	Ø0.257	Ø0.316	0.86	NOTE 2
D2199-19	18.90	18.10	Ø0.257	Ø0.257	0.58	NOTE 2
D2199-21	10.80	10.00	Ø0.257	Ø0.257	0.33	NOTE 2
D2199-23	26.18	25.38	Ø0.257	Ø0.316	0.81	NOTE 2
D2199-25	19.93	19.13	Ø0.257	Ø0.257	0.61	NOTE 2
D2199-27	27.34	26.54	Ø0.257	Ø0.316	0.84	NOTE 2
D2199-29	21.11	20.31	Ø0.257	Ø0.257	0.65	NOTE 2
D2199-31	15.55	14.75	Ø0.257	Ø0.257	0.45	NOTE 3

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING Ø0.750 X 0.049 WALL
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF DART SPEC. M304TR0.750W0.049
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D2199-XX" AND B/N BXXXXXX
PER QSI 044, 6.5.
- 8) WEIGHT: PER CHART
- 9) MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER.

Q2 MAR 08 2015
W10.132744

RELEASED

2015 FEB 04

ECN 15-522 915-522

F	INCORPORATED E1, REFORMATTED AND REDRAWN. ADDED -31. ADDED GREY SANDTEX FINISH.	AJS	14.09.26
E	ADDED -23 AND -25 PER TSR A565M. ADDED TEMPLATE & SPEC CTRL. DWG REDRAWN IN CAD	KE	98.04.28
D	ADDED -21	N/A	N/A
C	ADDED -17 AND -19	N/A	N/A
B	ADDED -11, -13 AND -15	N/A	N/A
A	NEW ISSUE	JB	1993
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. X
MFG. APPR.	DD	D2199	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT DETAILS	NTS
DATE	14.09.26	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMINGLED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

DART AEROSPACE LTD

Work Order:	132744
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Description: *Street*

Part Number:	D2199-1
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Inspection Dwg: 22199 Rev: F

Page 1 of 1

DAS

28

9-89

DAS

05

9-89

Measured by:

Date: MAY 26 2015

Audited by:

Dato:	15 05 27
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Preliminary Approval:

Date:

Rev

Date _____

Change

Added preliminary approval

Revised by

KJ

Approved

10.04.15